

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021907**Date Inspected:** 30-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

WELDING

This QA Inspector observed the following work in progress:

BAY 14

This QA Inspector observed ZPMC qualified welding personnel identified as 037779 perform welding by Shielded Metal Arc Welding (SMAW), on Deck panel of OBG Segment 14W. Weld joint is identified as DP3169-001-158. ABF Quality Control (QC) Inspector identified as Shen Jian was present to monitor the welding process. The welding variables recorded by ABF QC appeared to be in general compliance with WPS-B-P-2212-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 069493 perform welding by Shielded Metal Arc Welding (SMAW), on Deck panel of OBG Segment 14W. Weld joint is identified as DP3169-001-216. ABF Quality Control (QC) Inspector identified as Shen Jian was present to monitor the welding process. The welding variables recorded by ABF QC appeared to be in general compliance with WPS-B-P-2212-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 067520 perform welding by Flux Cored Arc Welding (FCAW), on Deck panel of OBG Segment 14W. Weld joint is identified as DP3170-001-356.

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ABF Quality Control (QC) Inspector identified as Shen Jian was present to monitor the welding process. The welding variables recorded by ABF QC appeared to be in general compliance with WPS-B-T-2232-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 067572 perform welding by Flux Cored Arc Welding (FCAW), on Deck panel of OBG Segment 14W. Weld joint is identified as DP3171-001-302. ABF Quality Control (QC) Inspector identified as Shen Jian was present to monitor the welding process. The welding variables recorded by ABF QC appeared to be in general compliance with WPS-B-T-2232-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 066038 perform repair welding by Shielded Metal Arc Welding (SMAW), on Floor beam to Bottom plate weld of OBG Segment 14W. Weld joint is identified as SEG3020D-052. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair and Critical welding repair report B-CWR2734-R1.

This QA Inspector observed ZPMC qualified welding personnel identified as 066398 perform repair welding by Shielded Metal Arc Welding (SMAW), on Floor beam to Bottom plate weld of OBG Segment 14W. Weld joint is identified as SEG3020E-056. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair and Critical welding repair report B-CWR2734-R1.

This QA Inspector observed ZPMC qualified welding personnel identified as 067775 perform welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 14W. Weld joint is identified as SEG3020K-035. ZPMC Quality Control (QC) Inspector identified as Wang Xiang Pin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2114-FCM.

This QA Inspector observed ZPMC qualified welding personnel identified as 045246 perform repair welding by Shielded Metal Arc Welding (SMAW), on Floor beam to Side plate weld of OBG Segment 14W. Weld joint is identified as SEG3020AL-003. ZPMC Quality Control (QC) Inspector identified as Wang Xiang Pin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair and welding repair report B-WR18585.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, phone: 15000422372 , who represents the Office of Structural Materials for your project.

Inspected By: Upadhye, Anand

Quality Assurance Inspector

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Reviewed By: Clifford, William

QA Reviewer